

GENERAL SHOP NOTES

SPECIFICATIONS:

ALL MATERIAL AND WORKMANSHIP TO BE IN ACCORDANCE WITH THE STATE OF VERMONT, AGENCY OF TRANSPORTATION, STANDARD SPECIFICATIONS FOR CONSTRUCTION DATED 2011, WITH ITS LATEST REVISIONS AND THE AASHTO LRFD BRIDGE DESIGN SPECIFICATIONS, FIFTH EDITION, AND ITS LATEST REVISIONS ALL AS MODIFIED BY CONTRACT SPECIFICATIONS.

MATERIAL:

UNLESS NOTED OTHERWISE, ALL STEEL TO BE AASHTO M270 GRADE 50W.
(T) INDICATES ZONE 2 CHARPY V-NOTCH TESTING REQUIRED.
UNLESS NOTED OTHERWISE, ALL STEEL ON THESE DETAILS SHALL BE FURNISHED UNDER BID ITEM 506.56.

DRILLING, PUNCHING, AND REAMING HOLE PROCEDURES:

RA REAMED ASSEMBLY
INDICATES CONNECTING PIECES PUNCHED OR DRILLED 1/4" UNDERSIZED, REAMED TO FULL SIZE WHILE ASSEMBLED, THEN MATCH MARKED.
UNLESS NOTED OTHERWISE, BOLT HOLES IN MATERIAL 3/8" OR LESS IN THICKNESS MAY BE CNC (COMPUTER NUMERICALLY CONTROLLED) PUNCHED OR CNC DRILLED FULL SIZE UNASSEMBLED. ALL MATERIAL THICKER THAN 3/8" IS TO BE DRILLED FOR UTILITY SUPPORTS.
ALL HOLES IN CROSSFRAMES & DIAPHRAGMS MUST BE DRILLED.

CLEANING:

ALL STEEL: SSPC-SP1, AS NECESSARY
ALL STEEL: SSPC-SP10, AFTER FABRICATION

PAINTING:

NO PAINT

DRAWING REFERENCE:

FLANGE SPLICES -PREFIXED "FS"
WEB CAMBERS -PREFIXED "WC"
GIRDER JOB STANDARDS -PREFIXED "X"
CROSSFRAME JOB STDS. -PREFIXED "M"
SHOP ASSEMBLY -PREFIXED "SA"
HORIZONTAL CURVE -PREFIXED "HC"
WELDING PROCEDURE -PREFIXED "WP"

SHOP PROCEDURE:

ALL FLANGE AND WEB PLATE SPLICES TO BE MADE BEFORE FINAL FITTING AND WELDING INTO GIRDER.
CAMBER TOLERANCE: -0" TO +3/4"
ALL RE-ENTRANT CUTS TO HAVE 2" MIN. RADIUS.
BEARING AREA, AS NOTED ON GIRDER DETAILS, INDICATES AREA THAT MUST BE FLAT AND TRUE TO RECEIVE SOLE PLATE.
DOR INDICATES DIRECTION OF MILL ROLLING.

INSPECTION:

SHOP INSPECTION BY TO BE DETERMINED.

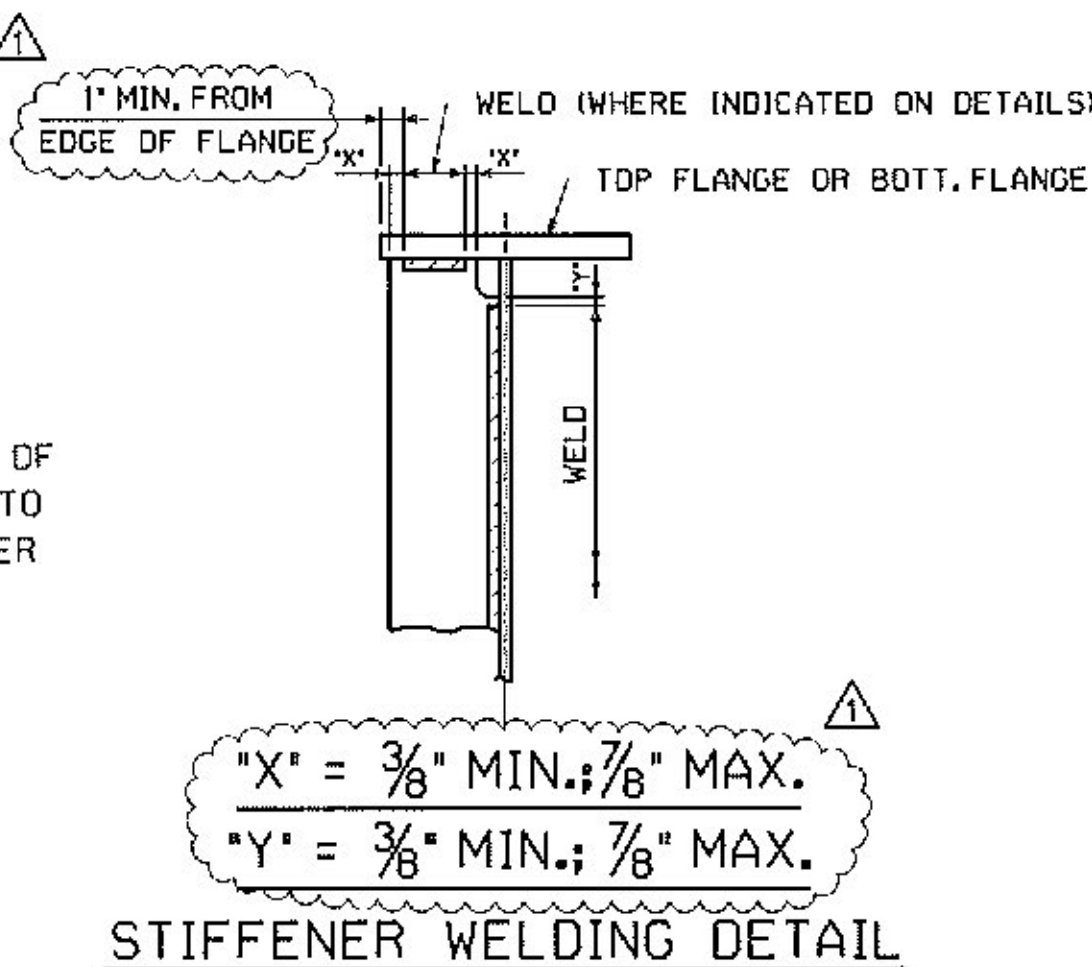
WELDING:

ALL WELDING IS TO CONFORM TO AWS D1.5-10.
WELDING METHODS, PROCEDURES, AND MATERIALS SHALL COMPLY WITH THE SPECIFIC PROCEDURE DESIGNATED IN THE WELD SYMBOL TAIL.
FOR WELDING STIFFENERS AND CONNECTION PLATES TO GIRDERS, SEE TYPICAL WELDING DETAIL.
FOR WELDING CROSSFRAMES, SEE SECONDARY MEMBER WELDING DETAIL.

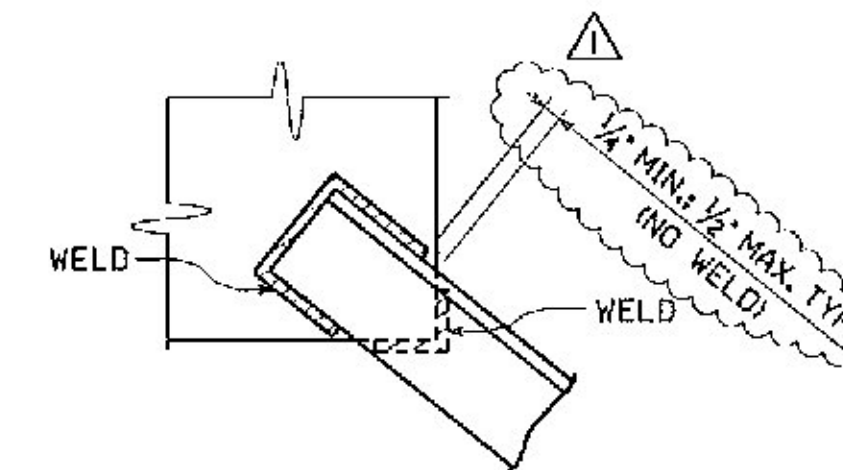
NON-DESTRUCTIVE TESTING:

FLANGE AND WEB PLATE SPLICES TO BE RADIOGRAPHICALLY TESTED, AS CALLED FOR ON DRAWINGS PREFIXED "FS" AND "WC", BY H.S.S.I.

MAGNETIC PARTICLE INSPECTION IS REQUIRED ON AT LEAST 1'-0" OF EVERY 10'-0" LENGTH OF FILLET WELDS AND 1'-0" OF SUCH WELDS LESS THAN 10'-0" IN LENGTH ON GIRDER WEB TO FLANGE, CONNECTION PLATES TO WEB AND FLANGE AND CROSSFRAME WELDS. TESTING PER THE YOKE METHOD, USING DC.



ALL CROSSFRAME WELDS ARE TO BE TERMINATED FROM EDGE OF GUSSET PLATES, FILL PLATES OR ANGLES AS INDICATED



Vermont Agency of Transportation
RECEIVED

CK'D BY J. CLARK OK'D BY J. GRIFFIN

February 12, 2013

RESUBMIT NO Approved

BY J. LACROIX DATE 02/25/2013

APPROVAL CHANGE; REVISED NOTE & WELDING DETAILS	MJD	MGK	2/5/13
NO.	REVISION	BY	CHK'D DATE
HOLDS			
BOLTS	GENERAL SHOP NOTES ROUTE NO. TH7 (BRIDGE ST.) OVER STEVENS BRANCH ROUTE NO. TH7 STA. 13+05.00 TO STA. 14+25.00 BRIDGE NO. 11, TOWN OF BARRE, COUNTY OF WASHINGTON STATE OF VERMONT AGENCY OF TRANSPORTATION		
COATING			
COBEXI			
SCALE N.T.S.	STATE CONT. OR REF. NO.	FED. AID PROJ. NO.	HSSJ PROJ. MGR
	GENERAL CONTRACTOR MILLER CONSTRUCTION, INC.	HSSJ PROJ. MGR KEN GLIDDEN	
VT	DRAWING MANAGER JOSH MURRY (IH)	MADE BY KCL	CHK'D BY SJA DATE 12/04/12
	HSSJ PROJECT NUMBER S-1120266A-1	DRAWING NUMBER	GN1 OF GN1

ENGLISH

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SHIPMENT BY PINKS FOR BRIDGE, INC. PREC. 2025752 SHIPPERECTA 506253

BY: mhw/mcc

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